

Date: Friday, 5/25/2007 8:37:11 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 32655		
Estimate Number	: 10498		
P.O. Number	: N/A	Part Number	: D2739
This Issue	: 5/25/2007	Drawing Number	: D2739 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 32582	Material	: N/A
Written By		Due Date	: 6/15/2007
Checked & Approved By	: <u>07.05.28</u>	Qty:	8 Um: Each
Comment	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web

B 29985

Jb 7-6-6

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.

5-Dburr

Jb 7-6-6

3.0	QC5	INSPECT WORK TO CURRENT STEP
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BE / 07-06-15



Comment: INSPECT WORK TO CURRENT STEP

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Jb 7-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 7/06/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:37:11 AM
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Drawing Name: WEB

Job Number: 32655

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Ph 07-06-19 (8)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

JD 7-6-15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

Ph 07-06-19

Job Completion



UL 07-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

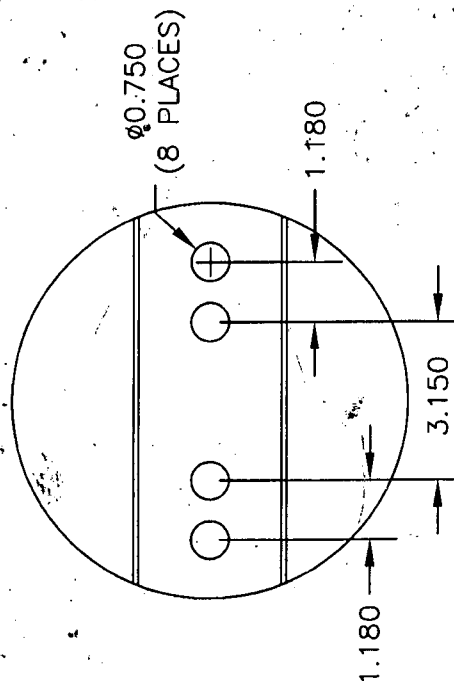
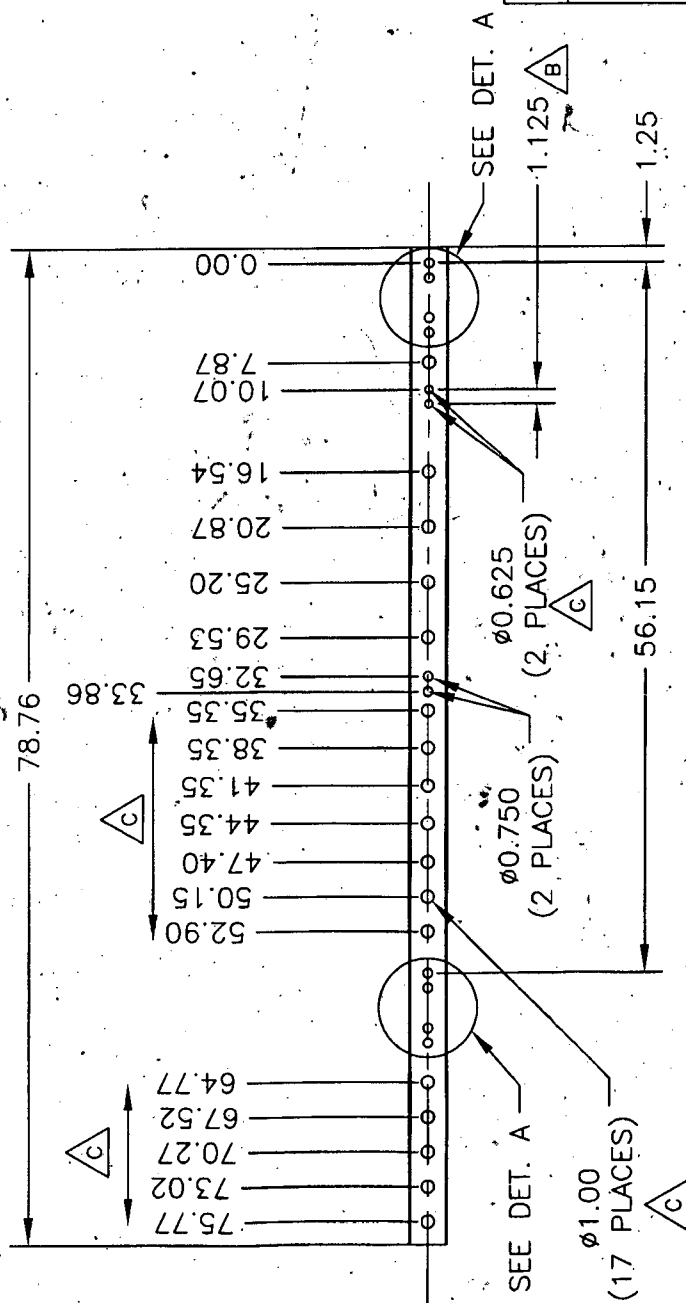
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN RH		DRAWN BY RH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]		APPROVED [Signature]		DRAWING NO. D2739	
DATE 06.01.05		TITLE WEB		REV. 0 SHEET 1 OF 1	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			

RELEASED
66-0257



DETAIL A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32655

D2739 WEB

1)	MATERIAL:	MAKE FROM D2600-5 EXTRUSION
2)	FINISH:	ACID ETCH, ALODINE PER DART QSI 005 4.1
3)		ALL DIMENSIONS ARE IN INCHES
4)		TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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